

Date:
User:Monday, 8/21/2006 2:11:18 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28251
Estimate Number : 10512
P.O. Number : *NIA*
This Issue : 8/21/2006 **S.O. No.** : *NIA*
Prsht Rev. : *NC*
First Issue : *NIA* **Type** : MACHINED PARTS
Previous Run : 27362
Written By : _____
Checked & Approved By : *RJ 06 08.21*
Comment : Est: A 02.04.15 New Issue NG
 Est: B 05.12.12 added deburr EC

Drawing Name : PLUG
Part Number : D26511
Drawing Number : D2651 REV. B
Project Number : N/A
Drawing Revision : B
Material : *NIA*
Due Date : 9/5/2006 **Qty:** 300 **Um:** Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



Comment: Qty.: 0.0421 f(s)/Unit Total : 12.6315 f(s)
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
 (M6061T6R0500)
 Batch: *m 101421*

2.0 HARDINGE HARDINGE CNC LATHE SMALL

PG



Issue P.O. 2057



Comment: HAAS CNC VERTICAL MACHINING #1 *turn per draw D2651 Rev B*
 1- Turn as per Folio FA219 and Dwg D2651
 2- Deburr

3.0 Q02 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Receive + Inspect for



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

transit damage 8/24/15 303

4.0 Q05 SECOND CHECK

S



Comment: SECOND CHECK

Inspect level 5

08.09.18

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr - as per dwg D2651

NIA C206109/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/11/06

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:11:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 28251

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06-10-03

300

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Only larger section necessary)

FC 06 10 24

300

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

a.m

06/01/06

300

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP15*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/11/06

Job Completion



U 06/10/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

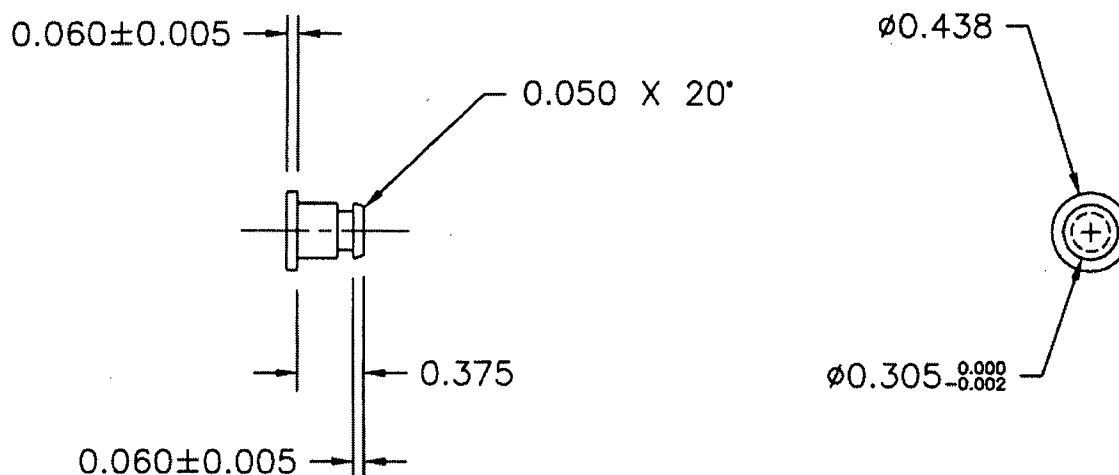


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

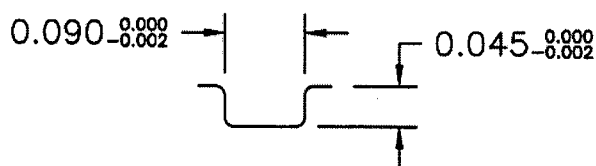
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28251

Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Handwritten signature and date: 06/11/06

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

300

D 2651-1

Plug

2057

MATERIAL: supplied by DART M101421

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Denise Robinson

Handwritten signature of Denise Robinson

Vankleek Hill, September 13, 2006

